

Date: Thursday, 04/01/2007 11:04:53 AM
 User: Linda Lacelle

Process Sheet

Split 70702-20

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLADE FITTING
 Job Number : 30112 -1
 Estimate Number : 12300
 P.O. Number : N/A
 This Issue : 04/01/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 29043
 Part Number : D3488042
 Drawing Number : D3488 / DSK101
 Project Number : N/A
 Drawing Revision : B / D
 Material : N/A
 Due Date : 30/01/2007 Qty: 16 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 06-02-28 JLM
 Est Rev: B As per Rev B 06-03-30 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6103003	alum billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Alluminum Round Billet D6103-003

Batch: 30170

BG 07-01-14 16

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per Dwg DSK 101 & Folio FA627

2-Deburr

BG 07-01-14 16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 07-01-14 16

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA627 & Dwg D3488

2-Deburr

JL/En 07-01-20 (44)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
07-02-20	2.0	W/O split for a Qty of 2.14 to remain on this W/O.	En	07/02/20	14	QSI042	07-02-20	
07/02/20	#5.0 #6.0	change steps # 6.0 and 5.0 around. last inspection level #2 is before inspection level #8	En	07/02/20		07-02-23	07-02-23	
		make change on W/O. perm. change	EE	07-02-23				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A.	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/02/20	# 2.0	Chatter marks found inside base of Blade Fin marks about .008" max. about 0.75" from edge of Blade Fin at the most Fin section.	QSI042	Acceptable. Parts on hold for next set-up to bore out max tolerance to remove the chatter marks. see split.	07/02/20	07-02-20	QSI042	07-02-20

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/26

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 04/01/2007 11:04:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 30112

Part Number: D3488042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mf 07/02/23 14

6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL/en 07/02/20 (X14)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YK 07/02/23 x 14

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103141 m-h/YK 07/02/26 (14X)

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 07/03/23 (14X)

10.0	ALS71032225	INSERT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert *M14393*

SL 07-03-23

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

SL 07-03-23 (14)

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07-03-23 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 07/03/26

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 04/01/2007 11:04:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 30112

Part Number: D3488042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Finishing

HL 07-03-23 (RA)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(11)
07/03/26

Job Completion



u 07-03-26

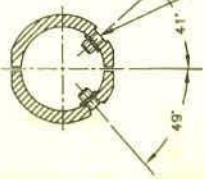
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

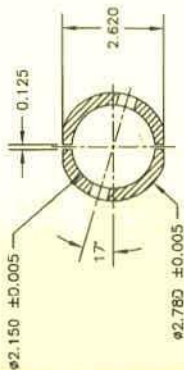
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



SECTION B-B

Ø0.297
BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



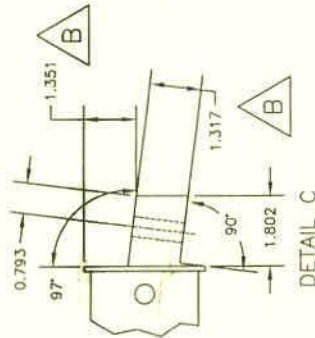
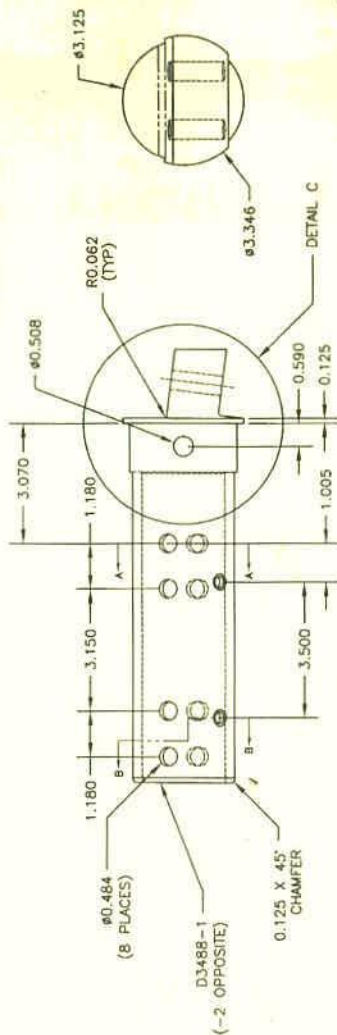
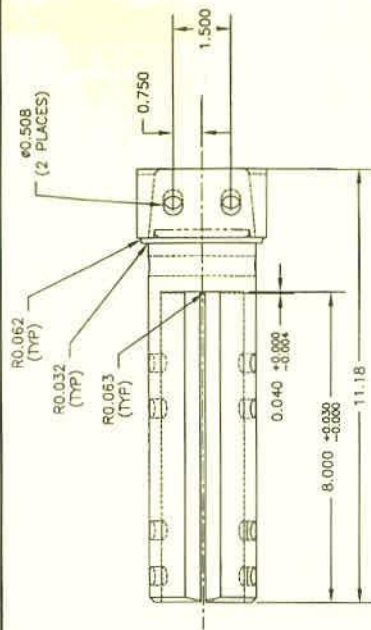
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
4	D3488-041	BLADE FITTING ASSEMBLY (LH)
4	D3488-042	BLADE FITTING ASSEMBLY (RH)
1	D3488-1	BLADE FITTING (LH)
1	D3488-2	BLADE FITTING (RH)
4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING
1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR
PER QQ-A-225/9
(REF. DART MATERIAL SPEC M7G75173R)

- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) INSTALL INSERTS AFTER POWDER COAT
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED
R06.03.03 #H
REV. 05
(N #78)

D3488-041 SHOWN (D3488-042 OPPOSITE)

DESIGN	DATE	CHANGE	THICKNESS
A	05.12.20	NEW ISSUE	
B	06.03.15		

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DESIGN	DATE	APPROVED	DRAWING NO.	REV. B
PH	06.03.15	PH	D3488	SHEET 1 OF 1
TITLE				SCALE
BLADE FITTING				1:3

DART AEROSPACE USA, INC.
PORT HADLOCK, MA

WFO
30112
u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ FAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	30112
Description: Blade Fitting, RH		Part Number:	D3488-2
Inspection Dwg: D3488	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.126	✓			
2.620	+/-0.010	2.619	✓			
0.793	+/-0.010	.795	✓			
1.351	+/-0.010	1.347	✓			
1.317	+/-0.010	1.317	✓			
90°	+/-0.1°	90°	✓			
1.802	+/-0.010	1.800	✓			
Ø0.508	+0.006/-0.001	.511	✓			
R0.062	+/-0.010	0.062	✓			
1.500	+/-0.010	1.500	✓			
8.000	+0.030/-0.000	8.008	✓			
11.18	+/-0.030	11.179	✓			
Ø0.484	+0.005/-0.001	.487	✓			
1.180	+/-0.010	1.179	✓			
3.150	+/-0.010	3.150	✓			
3.070	+/-0.010	3.072	✓			
0.590	+/-0.010	.592	✓			
0.125	+/-0.010	.129	✓			
1.005	+/-0.010	1.006	✓			
3.500	+/-0.010	3.499	✓			
Ø0.297	+0.005/-0.000	.300	✓			
Ø0.430	+/-0.010	.431	✓			
0.100	+/-0.010	.100	✓			

Measured by:	J.L	Audited by:	JML	Prototype Approval:	N/A
Date:	07/02/19	Date:	07/02/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	JML

W/O:		WORK ORDER CHANGES					
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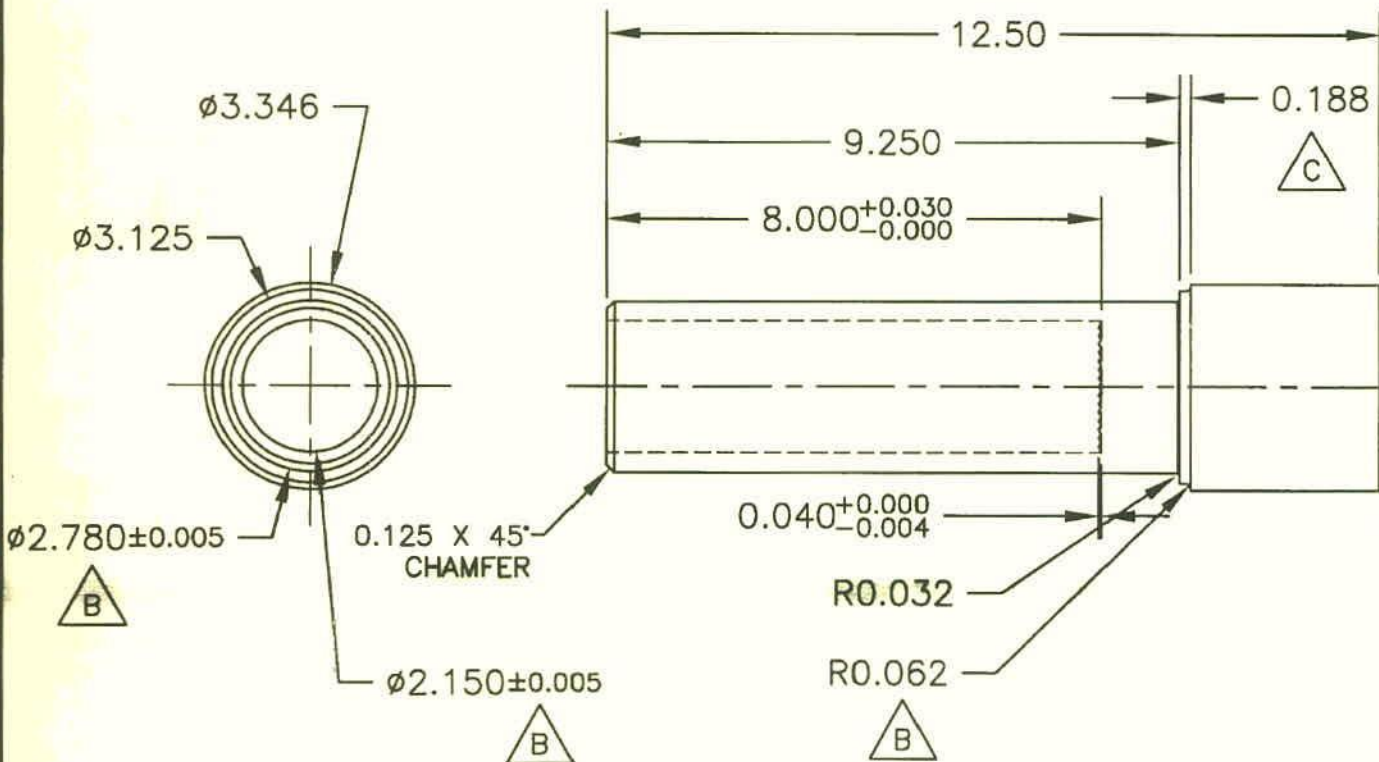
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART*26-5-09 H*

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
PH	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. D	
<i>PH</i>	<i>PH</i>	DSK 101	SHEET 1 OF 1	
DATE		TITLE	SCALE	
06.05.09		D3488-1/-2 TURNING DETAIL	1:3	
A	05.12.21	NEW ISSUE		
B	06.03.02	ADD TOLERANCES AND RADIUS		
C	06.04.17	0.188 WAS 0.125		
D	06.05.09	REMOVE DIAMETER FOR CHAMFER		

**DSK 101**

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

30112

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____